

Date: Tuesday, 01/04/2008 7:56:51 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP LEG
Job Number : 38262	
Estimate Number : 10382	
P.O. Number :	Part Number : D30655
This Issue : 01/04/2008 S.O. No! :	Drawing Number : D3065 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 35622C	Material :
Written By : <i>[Signature]</i>	Due Date : 08/04/2008 Qty: 50 Um: Each
Checked & Approved By :	
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF	
Est Rev:D Now on Water Jet 06-04-11 JLM	
Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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58



Comment: Qty.: 1.1338 sf(s)/Unit Total : 56.6895 sf(s)
Material: 6061-T6 0.080" thick
(M6061T6S.080) Batch: 107276 IB 8-4-1

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D
Dwg Rev: B
Prog Rev: B

IB 8-4-1

2-Deburr if necessary IB 8-4-1

51

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-4-1



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6 08/04/01 counts X51

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

[Signature] 08-04-03 51

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 38262

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(51)

Comment: INSPECT CHEMICAL CONVERSION COAT

1/4 08-04-03

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SB 08/04/04

(51)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/08

Comment: FINAL INSPECTION/W/O RELEASE

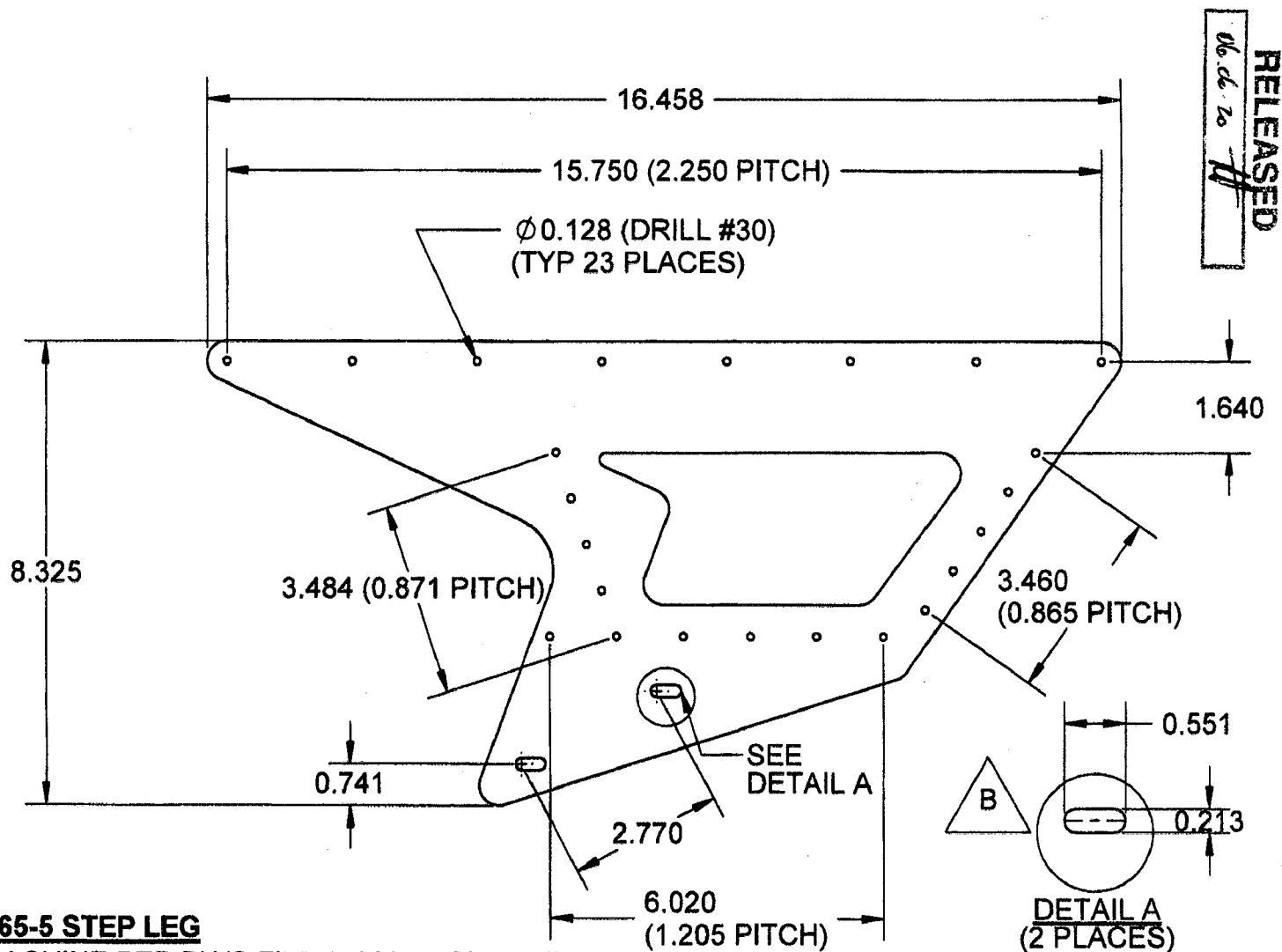
Job Completion



U 08/04/04

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
C	C.B.	DRAWING NO.	REV. B	
CHECKED SH	APPROVED [Signature]	D3065	SHEET 4 OF 5	
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:3	

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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